

Date: Thursday, 4/12/2007 9:34:21 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 31791		
Estimate Number	: 10347		
P.O. Number	: N/A	Part Number	: D28572
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D2857 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 30718	Material	: N/A
Written By	:	Due Date	: 5/10/2007 Qty: 24 Um: Each
Checked & Approved By	:		
Comment	: Est C 00.06.22 Removed P/O for powder coat EC Est D 06.03.30 Added level 8 EC		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	- M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"

Comment: Qty: 0.4594 f(s)/Unit Total: 11.0250 f(s)
Material: 2.00" X 1.25"
6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
(M6061T6B200001250)
Batch M100451

J.F. 07/04/17 (25)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks 5.2"

J.F. 07/04/17 (25)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio D2857-2

JL/J.F. 07/04/18 24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F./JL07/04/18 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 07/04/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/19	3	- 1 part scrap - operator forgot to retake "A" origin in beginning of shift	<i>[Signature]</i> 05/04/19	- scrap + destroy	J.L. 07/04/19	<i>[Signature]</i> 07/04/19	<i>[Signature]</i> 05/04/19	<i>[Signature]</i> 07/04/19

NOTE: Date & initial all entries

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Drawing Name: HINGE BRACKET

Job Number: 31791

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

an 07/04/19

24

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

J.L 07/04/19

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

fol

07/04/23

24

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M.A

07/04/23

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

HL

07-04-23

24

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/04/24

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/04/24

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/04

Job Completion



u 07.04.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31791
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857	Rev: A B	Page 1 of 1	

VE 04.07.12

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

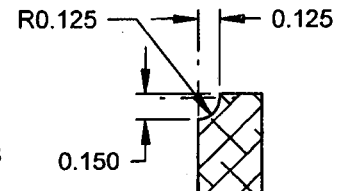
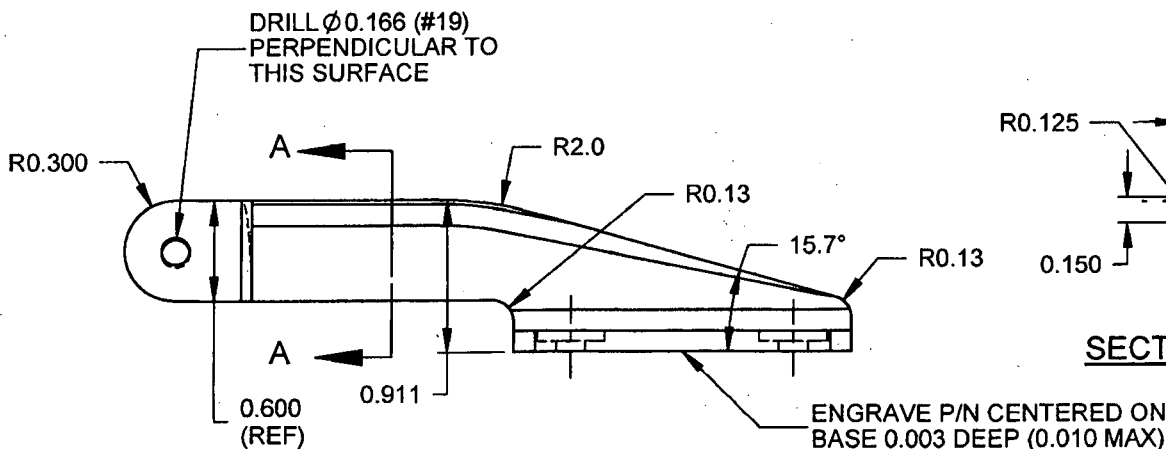
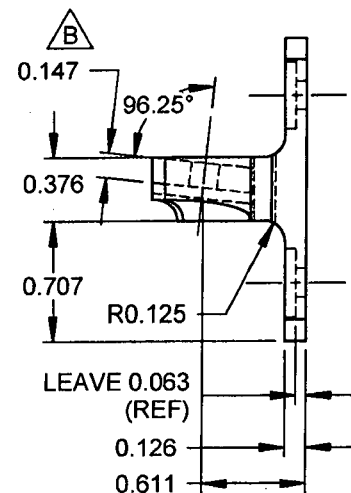
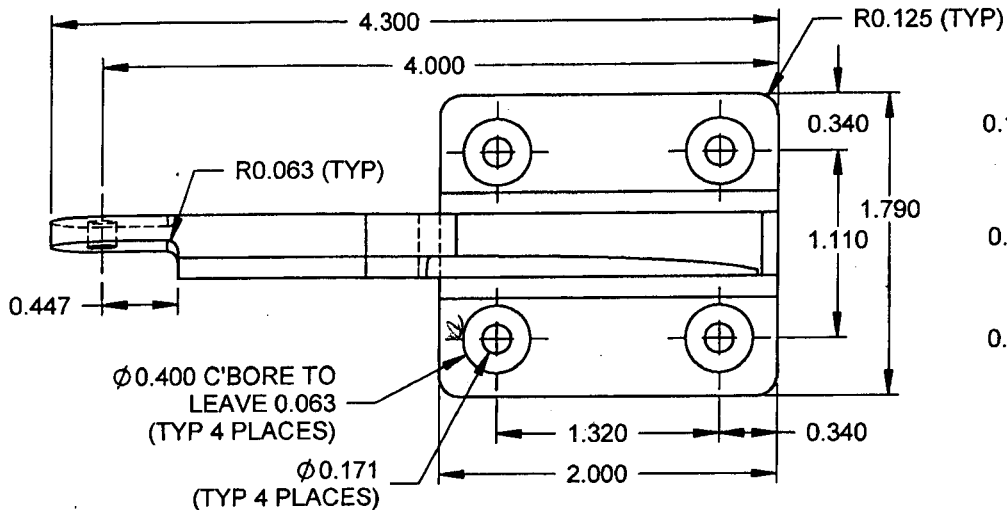
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.309"	✓			
0.340	+/-0.010	.339"	✓			
1.110	+/-0.005	1.112"	✓			
1.790	+/-0.010	1.792"	✓			
1.320	+/-0.005	1.322"	✓			
2.000	+/-0.010	2.002"	✓			
Ø0.171	+0.005/-0.000	Ø .171"	✓			
0.340	± 0.010	.339"	✓			
0.147	+/-0.010	.153"	✓			
0.376	+/-0.010	.377"	✓			
0.126	+/-0.010	.122"	✓			
0.611	+/-0.010	.609"	✓			
0.063	+/-0.010	.060"	✓			
4.000	± 0.010	4.002"	✓			
Ø0.166	+0.005/-0.000	Ø .167"	✓			
0.911	+/-0.010	.913"	✓			
0.600	+/-0.010	.599"	✓			
0.447	± 0.010	.447"	✓			
0.125	+/-0.010	.128"	✓			
0.150	+/-0.010	.149"	✓			

Measured by: J.F.	Audited by: En	Prototype Approval:	N/A
Date: 07/04/18	Date: 07/04/18	Date:	N/A

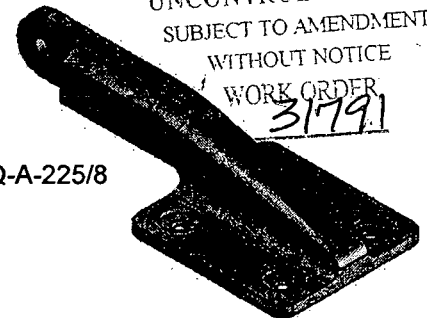
Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	

DART

DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06-10-13**SECTION A-A****D2857-1 HINGE BRACKET**
D2857-2 OPPOSITE**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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